

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029673**Date Inspected:** 03-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge Manufacturing**Location:** Reedsport, OR**CWI Name:** Mike Inman**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Skyway Traveler Rail Replacement**Summary of Items Observed:**

Skyway Traveler Rail Replacement - CCO # 24S0

The QAI periodically observed American Bridge Manufacture (ABM) welding personnel Mike Hebert perform base material preheating, preparation and welding operations. The welding operation was being performed by using the Flux Cored Arc Welding Gas Shielded (FCAW-G) process. Fillet welding performed on the traveler rail to trolley stop assembly on traveler rail number 3034TR1.

This QAI observed QC Inspector monitoring the welding operation and verifying the electrical welding parameters

according to Welding Procedure Specification (WPS) number ABM-SAS-08, they appeared to be in general compliance.

This QAI during random inspection of traveler rails monitored heat straightening operations of traveler rails 3030TR1, and 3031TR1 according to camber heat corrections plan. This QAI observed QC Inspector monitoring the heating operation and verifying the temperature parameters with temperature sticks, these heating operations appeared to be in general compliance.

**Supplemental Cable Bands - CCO # 274**

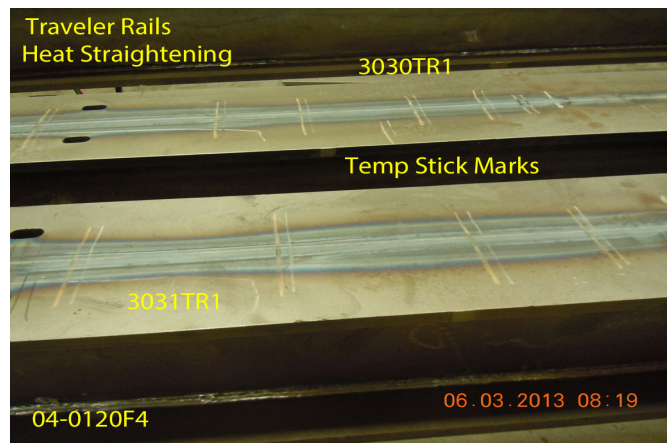
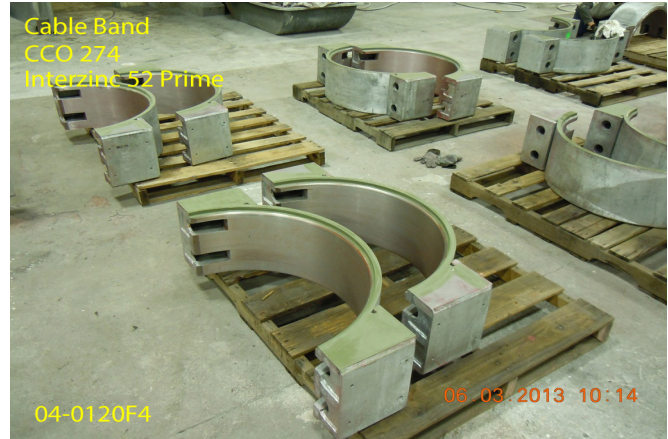
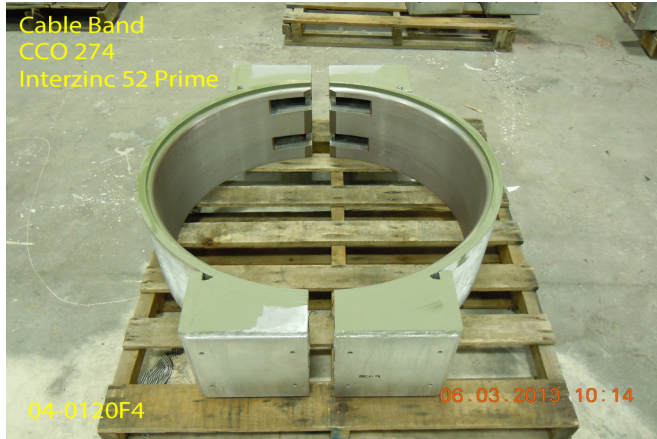
The QA Inspector periodically observed ABM coating personnel performing painting operations on the Supplemental Cable Bands with Interzinc 52. Second coating of cable band machined areas were completed today.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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**Inspected By:** Combs,Dennis

Quality Assurance Inspector

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**Reviewed By:** Riley,Ken

QA Reviewer